

# Work Order ID 62852

Tuesday, October 12, 2010 11:42:41 AM



Page 1

Item ID:	D2221	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	350 Basket Base					
Start Date:	10/12/2010	Start Qty:	1.00			
Required Date:	10/22/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	10/12	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2221	Rev H								

100		0.00							
	Large Fab								
Large Fab									
Large Fab									
	Memo	0.00							
	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221								
	2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221								
	3- tack weld mesh on basket as per dwg D2221								
	A/R ER316 S.S. Rod Batch: 11585								
	4- AUTOMATIC LID OPENER								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC									
Quality Control	Memo	0.00							

*Pl 10.10.04*  
*10/11/15*  
*BE*  
*10.11.09*  
*1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62852**

Tuesday, October 12, 2010 11:42:41 AM

Page 2

Item ID: D2221

Accept

Setup Start

Revision ID:

Stop

Item Name: 350 Basket Base

Start Date: 10/12/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BL 10-11-11.

10-11-15  
Pw A  
mchell

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 10/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

U115291.

1 BR 10-11-11

Powder Coating

Memo

0.00

1- Plug holes prior to

1ST COAT:

START TIME: 9:00

OVEN TEMPERATURE: 1420°

FINISH TIME: 9:30

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

ES 10/11/16 @

W/O:		WORK ORDER CHANGES					
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Page 4

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Revision ID:

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Start Date: 10/12/2010 Start Qty: 1.00

Required Date: 10/22/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: *6-A*

0.00



Packaging

Memo

0.00

Packaging

*w/o 62848**EP 10/11/16 ①*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*CA 10/11/17 ①**PS 10-11-17 ①*

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**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, October 12, 2010 11:42:45 AM

Page 1

Work Order ID: 62852

Parent Item: D2221

Parent Item Name: 350 Basket Base




Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM  
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N  
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2221-1  Rib		Manufactured	No			100	Each	14.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>WA</div> <div>14</div> <div></div> </div> <div> <div>61091</div> <div>2</div> <div></div> </div> <div> <div>61424</div> <div>12</div> <div></div> </div>													
✓ D2221-5  Rib		Manufactured	No			100	Each	12.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>WA</div> <div>12</div> <div></div> </div> <div> <div>60957</div> <div>4</div> <div></div> </div> <div> <div>61753</div> <div>8</div> <div></div> </div>													
✓ D2221-7  Rib		Manufactured	No			100	Each	6.0000	1				
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>WA</div> <div>6</div> <div></div> </div> <div> <div>61180</div> <div>2</div> <div></div> </div> <div> <div>61754</div> <div>4</div> <div></div> </div>													

362519 → ①

②  
1

①

Ppl 10.10.04

Ppl 10.10.04

Ppl 10.10.04

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 62852

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D2232-3

Manufactured No

100

Each

8.0000

2

2



Basket Hinge

Location

Loc Qty

Loc Code

WA

8

61182

2

61755

6



B63003 → (2)

D2235-1

Manufactured No

100

Each

16.0000

2

2



Basket Rib

Location

Loc Qty

Loc Code

WA

16

61471

6

62254

10



B62988 → (2)

D2581

Manufactured No

100

Each

51.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

51

60470

31

61953

20



(2)

D3442-1

Manufactured No

100

Each

16.0000

2

2



Shim

Location

Loc Qty

Loc Code

WA

16

60177

4

61181

12



(2)

B61014.04

Tuesday, October 12, 2010 11:42:45 AM

Shop Packet Print

Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

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Tuesday, October 12, 2010 11:42:45 AM

Page 3

Work Order ID: 62852

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3825-041

Manufactured No

100

Each

8.0000

2

2



Rib Assembly (Basket End)

Location

Loc Qty

Loc Code

WA

8

61179

2

61757

6



B62994 → ②

D3826-041

Manufactured No

100

Each

8.0000

2

2



Rib / Gusset Assembly

Location

Loc Qty

Loc Code

WA

8

61178

2

61676

6



B62986 → ②

D3827-041

Manufactured No

100

Each

9.0000

1

1



Rib Assembly (Inboard)

Location

Loc Qty

Loc Code

WA

9

61177

3

61758

6



①

D3832-1

Manufactured No

100

Each

3.0000

1



Mesh (Base)

Location

Loc Qty

Loc Code

WA

3

61451

3



B62932 → ①

Tuesday, October 12, 2010 11:42:45 AM

Shop Packet Print

Page 3

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# Picklist Print

Tuesday, October 12, 2010 11:42:45 AM

Page 4

Work Order ID: 62852



Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

14.0000

2

2



Mesh (Base End Face)



*Pl 10.19.04*

Location

Loc Qty

Loc Code

WA

14

61285

6

62383

8

*(2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

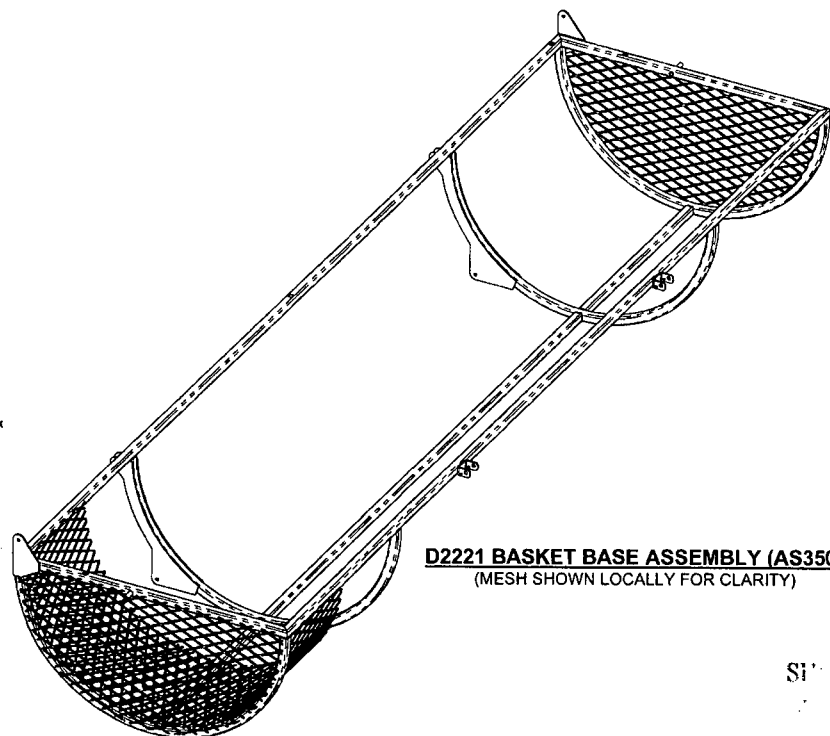
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries





**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RECEIVED  
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN D6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

UNC  
SUF

NO. 6283.2

2/10/12

**Dart Aerospace Ltd**

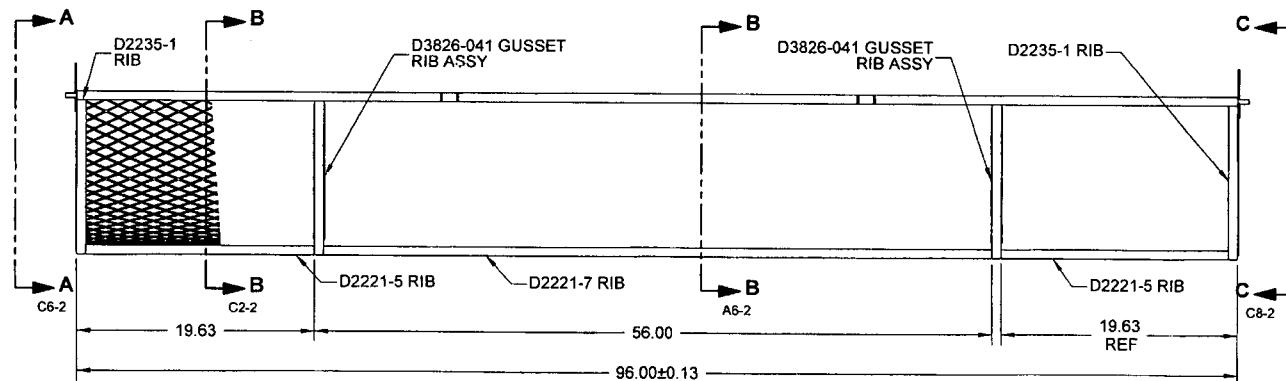
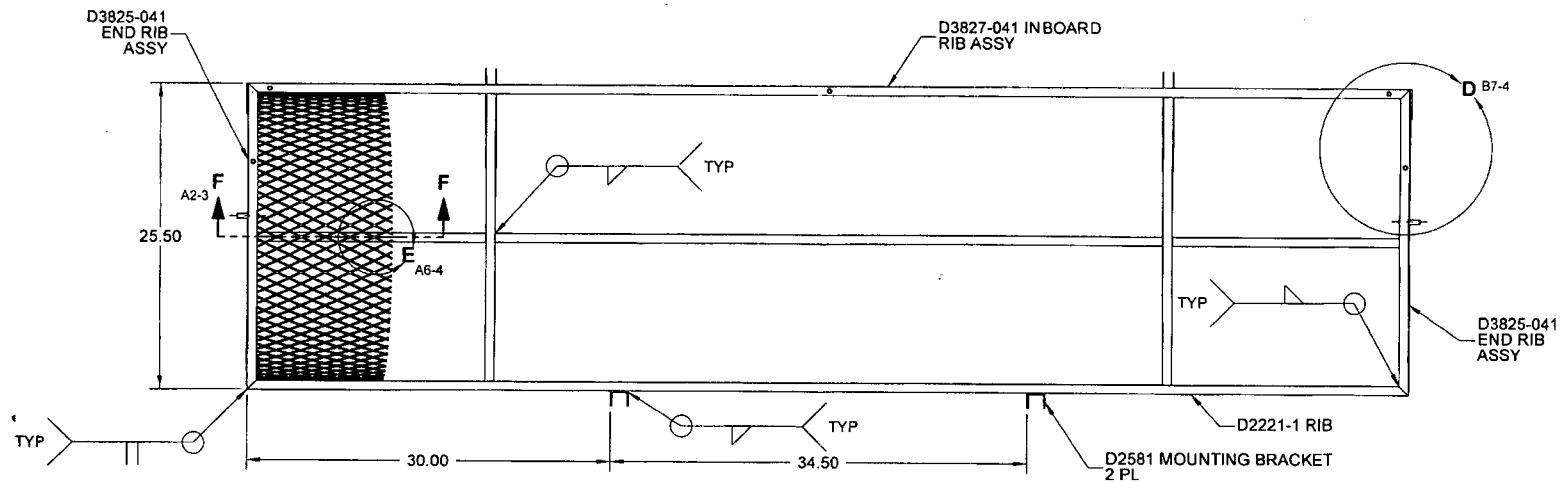
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**NOTE:** Date & initial all entries



**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
06/11/18 JAD

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET BASE ASSEMBLY (350) NTS</b>	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

*21062857*

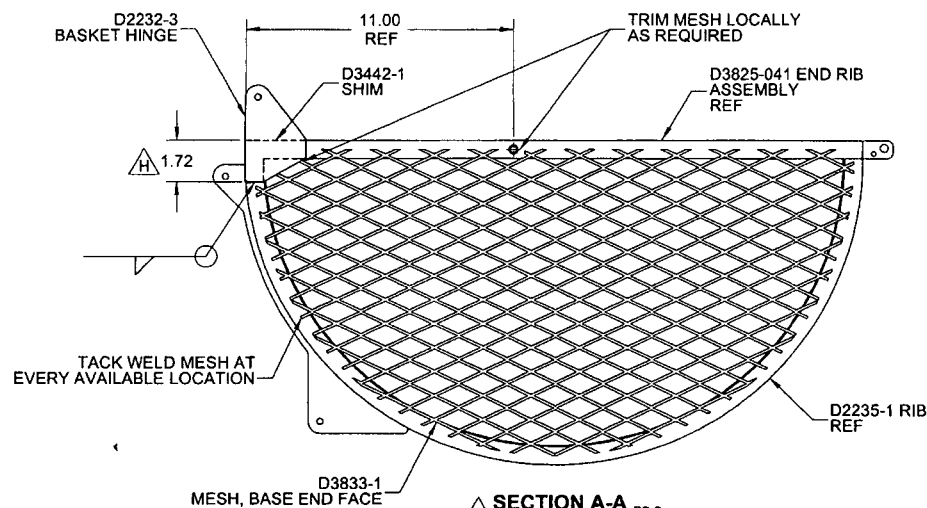
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

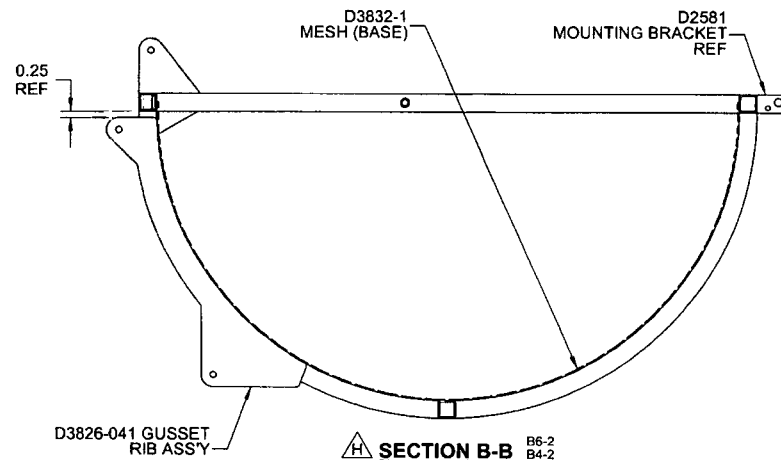
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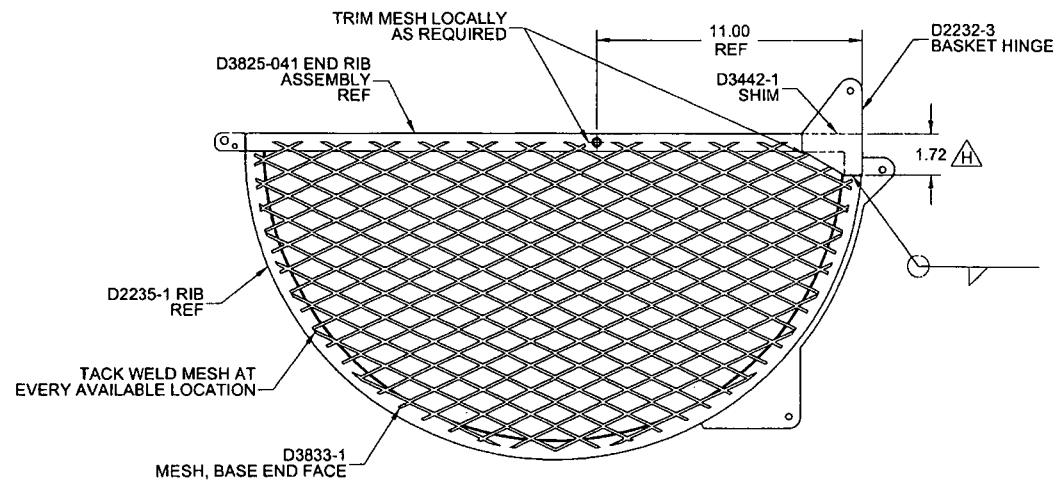
**NOTE:** Date & initial all entries



**SECTION A-A**  
SCALE 2X B7-2



**SECTION B-B**  
SCALE 2X  
(D3833-1 MESH NOT SHOWN FOR CLARITY)  
B6-2  
B4-2



**SECTION C-C**  
SCALE 2X B2-2

**RELEASE**  
03/11/16

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D2221</b>	REV. H
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET BASE ASSEMBLY (350)</b>	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

*010 62552*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

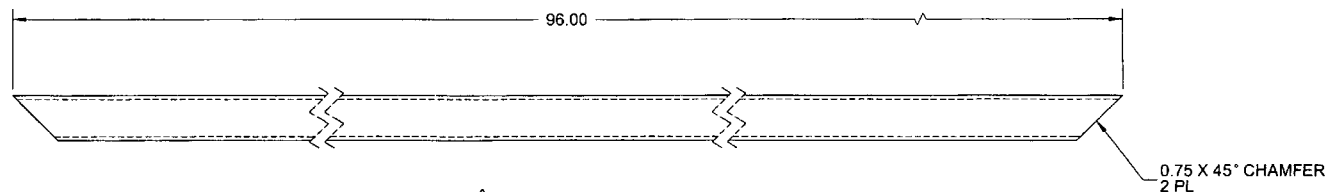
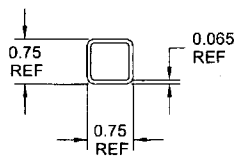
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

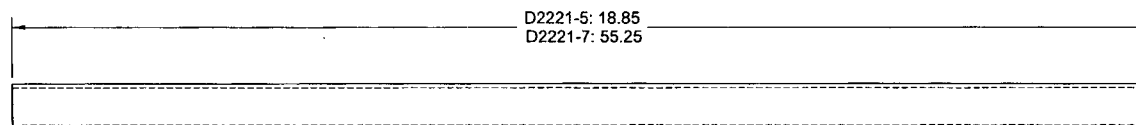
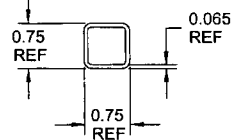
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D2221-1 RIB**



**D2221-5/-7 RIB**

**RELEASED**  
08/10/18

*2166285*

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries